



Dart Aerospace Ltd.
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RBW6305G19631-3G

Job Sheet 200002



Part No: RBW6305G19631-3G

Job Qty: 1 pcs

Part Name: Main Rotor Drive Tool 1 (Box 1 Of 2)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/5/19

Job Tracking No:

Due Date: 9/19/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G19631-3G Rev 3 IPP Rev A 18.03.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	9/19/19		0.00	1.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
110	Small Fab - 2 - B4B	1 pcs	9/19/19		0.00	1.00	Small Fab - 1 - B4B		MLL
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
							Small Fab - 8 - B4B		
120	QC 5	1 pcs	9/19/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		



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Container No: S238147



Part: RBW6305G19631-3G

Job No: 200002

Serial No/Batch: S238147

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 12/09/19

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QC 5 - 30					
QC 5 - 40					
QC 5 - 61					
QC 5 - 81					
130 Packaging 3-1 - Stock - B4B 1 pcs	9/19/19	0.00 0.00			
Packaging 3 - 1 - B4B					
Packaging 3 - 2 - B4B					
Packaging 3 - 3 - B4B					
Packaging 3 - 4 - B4B					
Packaging 3 - 5 - B4B					
Packaging 3 - 6 - B4B					
Packaging 3 - 7 - B4B					
Packaging 3 - 8 - B4B					
Packaging 3 - 9 - B4B					
Packaging 3 - 10 - B4B					
Packaging 3 - 11 - B4B					
Packaging 3 - 12 - B4B					
Packaging 3 - 13 - B4B					
Packaging 3 - 14 - B4B					
Packaging 3 - 15 - B4B					
Packaging 3 - 16 - B4B					
Packaging 3 - 17 - B4B					
Packaging 3 - 18 - B4B					
Packaging 3 - 19 - B4B					
Packaging 3 - 20 - B4B					
Packaging 3 - 21 - B4B					
Packaging 3 - 22 - B4B					
Packaging 3 - 23 - B4B					
Packaging 3 - 24 - B4B					
Packaging 3 - 25 - B4B					
Packaging 3 - 26 - B4B					
Packaging 3 - 27 - B4B					
Packaging 3 - 28 - B4B					
Packaging 3 - 29 - B4B					
Packaging 3 - 30 - B4B					
Packaging 3 - 31 - B4B					
Packaging 3 - 32 - B4B					
Packaging 3 - 33 - B4B					
Packaging 3 - 34 - B4B					
Packaging 3 - 35 - B4B					
Packaging 3 - 36 - B4B					
140 QC 21 - FG 1 pcs	9/19/19	0.00 0.00			
QC 21 - FG - 21					
QC 21 - FG - 70					
QC 21 - SA - 53					

Part Op 100 - (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1650-E 3-Debur holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW6305G19631-3G-23 and RBW6305G19631-3G-25 to RBW6305G19631-3G-21 foam as per DWG. 6-Glue foam to case and pack case as per DWG

110 - (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1650-E 3-Debur holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW6305G19631-3G-23 and RBW6305G19631-3G-25 to RBW6305G19631-3G-21 foam as per DWG. 6-Glue foam to case and pack case as per DWG

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location:)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1650-E RB F6A	Case GA213	1 Ea (1 ea)	100-Small Fab - 1	5204623
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	110-Small Fab - 2 - B4B	5163934
RB41011	Dart Tooling Placard, Aluminum	1 pcs (1 ea)	110-Small Fab - 2 - B4B	6021040
92F RBW6305G13231-3G	Gimball Carbon Seal Installer	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5235018
95 RBW6305G13731-3G	Gimball Carbon Seal Remover	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5235119
159 RBW6305G14031-3G	Gimball Carbon Seal Remover	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5235824
92F RBW6305G14331-3G	Upper Module Lip Seal Installer	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5235103
92 RBW6305G17131-3G	Drive Quill Seal Housing Removal Tool	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5235014
94 - 92 RBW6305G17631-3G	Tool Pump 1-2-3 Drive Quill Lip Seal Remover	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5235121
92 RBW6305G17931-3G	Tool Pump 1-2-3 Drive Quill Lip Seal Installer	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5235121
03 RBW6305G18251-3G	Guide Pumps/Ecs Drive Quill Seal Housing Installer	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5235121
RBW6305G19631-3G-19	Bottom Foam use in case APP-1650-E	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5235121
RBW6305G19631-3G-21	Top Foam use in case APP-1650-E	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5235121
94 RBW6305G19631-3G-23	Inside Placard	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5235121
94 RBW6305G19631-3G-25	Tool Layout Placard	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5235121

Job Allocations

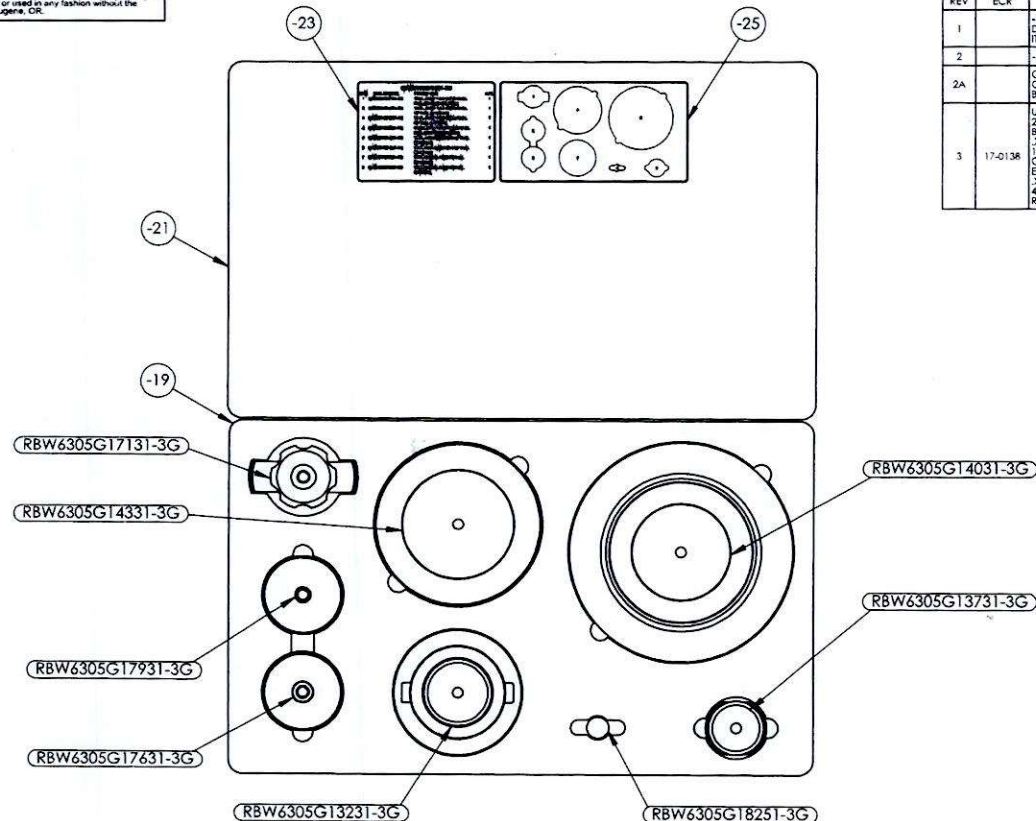
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	APP-1650-E	1	10	0
110-Small Fab - 2 - B4B	97524A032	4	221	0
	RB41011	1	250	0
	RBW6305G13231-3G	1	0	0
	RBW6305G13731-3G	1	0	0
	RBW6305G14031-3G	1	0	0
	RBW6305G14331-3G	1	0	0
	RBW6305G17131-3G	1	0	0
	RBW6305G17631-3G	1	0	0
	RBW6305G17931-3G	1	0	0
	RBW6305G18251-3G	1	0	0
	RBW6305G19631-3G-19	1	2	0
	RBW6305G19631-3G-21	1	2	0
	RBW6305G19631-3G-23	1	3	0
	RBW6305G19631-3G-25	1	1	0

Part Specifications

Specifications could not be found.

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVE	
1		-19 CHD FOAM DIMENSIONS, ADDED FINGER HOLES Ø3.164 CUTOFF PER R.W. CHD -21 FOAM DIMENSIONS, CHD CUTOFF TO RECESS FOR -23 & -25 PER R.W. ADDED MISSING TOOL NUMBER & ITEM NUMBERS TO -23 PER R.W.	3/29/2011	RJC	RW	
2		-19 CHD FOAM CUTOFF DEPTH DIMENSIONS SO TOOLS ARE SUB-FLUSH.	2/6/2013	BM	SE	
2A		CHD TITLE WAS MAIN ROTOR DRIVE SEAL REPLACEMENT TOOL KIT IS MAIN ROTOR DRIVE TOOL KIT 1. CHD BOM DESCRIPTIONS -1 THRU -15 TO MATCH PARTS MANUAL. -23 CHD DESCRIPTIONS, WAS BUYOUT IS MANUFACTURED. CHD -25 WAS B/O IS MANUFACTURED.	10/30/2013	CFS	RJC	
3	17-0138	UPDATED TO NEW DRAFTING STANDARD. -1 THRU -15 DELETED DASH NUMBERS. -19 CHD DIMS WAS 2.80 S 1.00. WAS SP IS 45°. ADDED DIM 2.00. DELETED DIM 1.40. 10° CHD B/O INFO WAS 120 BLACK I.R. SPECIALLY IS ETHAFOAM 220 BLACK CASE SOLUTIONS. CHD TOLERANCE WAS .XXX ± .005 .XX ± .01 S .XXX ± .010 XX ± .03. -21 CHD DIMS WAS 29.12 S 29.19. WAS 18.09 IS 18.10. WAS 1.80 IS 1.77. WAS 2.06 IS 2K. 9° 13. ADDED DIMS 4X 45°. 2K 1.00. 2K 2.75. 1.37. 8K 1.18. SIMPLIFIED CUTOFF ON BACK OF FOAM. DELETED DIM 4X 2". CHD B/O INFO WAS C200 FLAT BLACK I.R. SPECIALLY IS ETHAFOAM 220 BLACK CASE SOLUTIONS. -21. -22. -25 CHD TOLERANCE WAS .XXX ± .005 .XX ± .01 IS .XXX ± .010 XX ± .03. -23. -25 ADDED USE PDF NOTE. -23 CHD DIM WAS 5.50 IS 5.00. WAS 8.37 (X4) IS 4X 8.13. DELETED TEXT ARIAL 3/16 LETTERS (X4). ARIAL 1/8 LETTERS. -25 CHD DIM WAS 8.37 (X4) IS 4X 8.13. WAS 5.50 IS 5.00. DELETED TEXT ARIAL 1/8 LETTERS.	6/13/2017	RJC	JAG	

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 200002 MLC
19-09-05

NOTE:

1. REFERENCE AGUSTA T/N 3G6305G19631.
2. ALSO SOLD WITH KIT RBW6305G01531-3G.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			1		TOOL PUMP 1-2-3 DRIVE QUILL SEAL HOUSING REMOVAL		RBW6305G17131-3G	1
			1		TOOL PUMP 1-2-3 DRIVE QUILL UP SEAL INSTALLER		RBW6305G17931-3G	1
			1		TOOL PUMP 1-2-3 DRIVE QUILL UP SEAL REMOVER		RBW6305G17631-3G	1
			1		GUIDE PUMPS/ECS DRIVE QUILL SEAL HOUSING INSTALLER	6061	RBW6305G18251-3G	1
			1		TOOL UPPER MODULE UP SEAL INSTALLER		RBW6305G14331-3G	1
			1		TOOL UPPER MODULE UP SEAL INSTALLER		RBW6305G14031-3G	1
			1		TOOL GIMBAL CARBON SEAL INSTALLER		RBW6305G13231-3G	1
			1		TOOL GIMBAL CARBON SEAL REMOVER		RBW6305G13731-3G	1
		B/O	-17	1	CASE	PLASTIC	PELICAN CASE # APP-1450-E	N/S
		B/O	-19	1	BOTTOM FOAM	ETHAFOAM 220, BLACK	8.71 X 17.97 X 29.12 (CASE SOLUTIONS)	2
		B/O	-21	1	TOP FOAM	ETHAFOAM 220, BLACK	1.77 X 18.10 X 29.19 (CASE SOLUTIONS)	3
			-23	1	INSIDE PLACARD	PLASTIC		4
			-25	1	TOOL LAYOUT PLACARD	PLASTIC		5
		B/O		1	DART PLACARD	ALUMINUM	RB41011	N/S

		TITLE	
		MAIN ROTOR DRIVE TOOL KIT 1	
DWG NO.		REV	
RBW6305G19631-3G		3	
MATL	UNLESS OTHERWISE SPECIFIED		
TEXT	DIMENSIONS ARE IN INCHES		
UNIT	XXX ± .005 FRACTIONS ± 1/16		
FINISH	XX ± .01 ANGLES ± 5°		
SPEC	X ± .1 SURFACES ± 125		
DRAWN BY:	CLOUGH	1. BREAK ALL SHARP EDGES	
CHECKED:	DD 06/14/2017	.015 X 45° OR .015R	
DRWS APPR:	AA 06/14/2017	2. DIMENSIONAL LIMITS APPLY	
QA APPR:	JL 06/28/2017	AFTER PLATING	
APPROVED:	JAG 07/07/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
		USED ON MODEL	
		AW139	
SCALE	1:6	DATE	2/7/2011
		SHEET 1 OF 5	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					